

Date: Thursday, 2/23/2006 10:23:37 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 25918					
Estimate Number	: 11030					
P.O. Number	: N/A			Part Number	: D2803042	
This Issue	: 2/23/2006 S.O. No. : N/A			Drawing Number	: D2803 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: N/A			Material	: N/A	
Written By	: <u>See Comment Below.</u>			Due Date	: 3/22/2006	
Checked & Approved By	: <u>KJ 06.02.23</u>			Qty:	10	Um: Each
Comment	: Est F 050330 MS21043-3 was MS21042L3			KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D28032	STA 84 Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 84 BRACKET	
		Pick:	
		Qty Part Number Description Batch	
		1 D2803-2 Bracket <u>B 25929</u>	
2.0	D28052	Stop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STOP	
		Pick:	
		Qty Part Number Description Batch	
		1 D2805-2 Stop <u>10 B 24620</u>	<u>SB 06/03/14 10</u>
3.0	D2809	Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing	
		Pick:	
		Qty Part Number Description Batch	
		1 D2809 Bushing <u>B25959</u> <u>540 06:03:20</u> <u>10</u>	<u>SB 06/03/14 10</u>
		Press D2805-2 into arm as per Dwg D2803	
			<u>SB 06/03/14 10</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 25918

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0



INSPECT PARTS AS THEY COME OFF MACHINE

(10)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 02/23/06 (10)

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

8.0 AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	<u>M17944</u>

(20)

9.0 MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	<u>M19099</u>

(20)

10.0 NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	<u>M17944 (16)</u>

M19633

A/R LPS-3 Corrosion Spray M17045

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

5A0 08:03:20

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: BRACKET ASSEMBLY

Job Number: 25918

Part Number: D2803042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

SM 06/03/20

10

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

13.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST156

C Sole 103/21 70

14.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

70 06/03/23

Job Completion



U 06-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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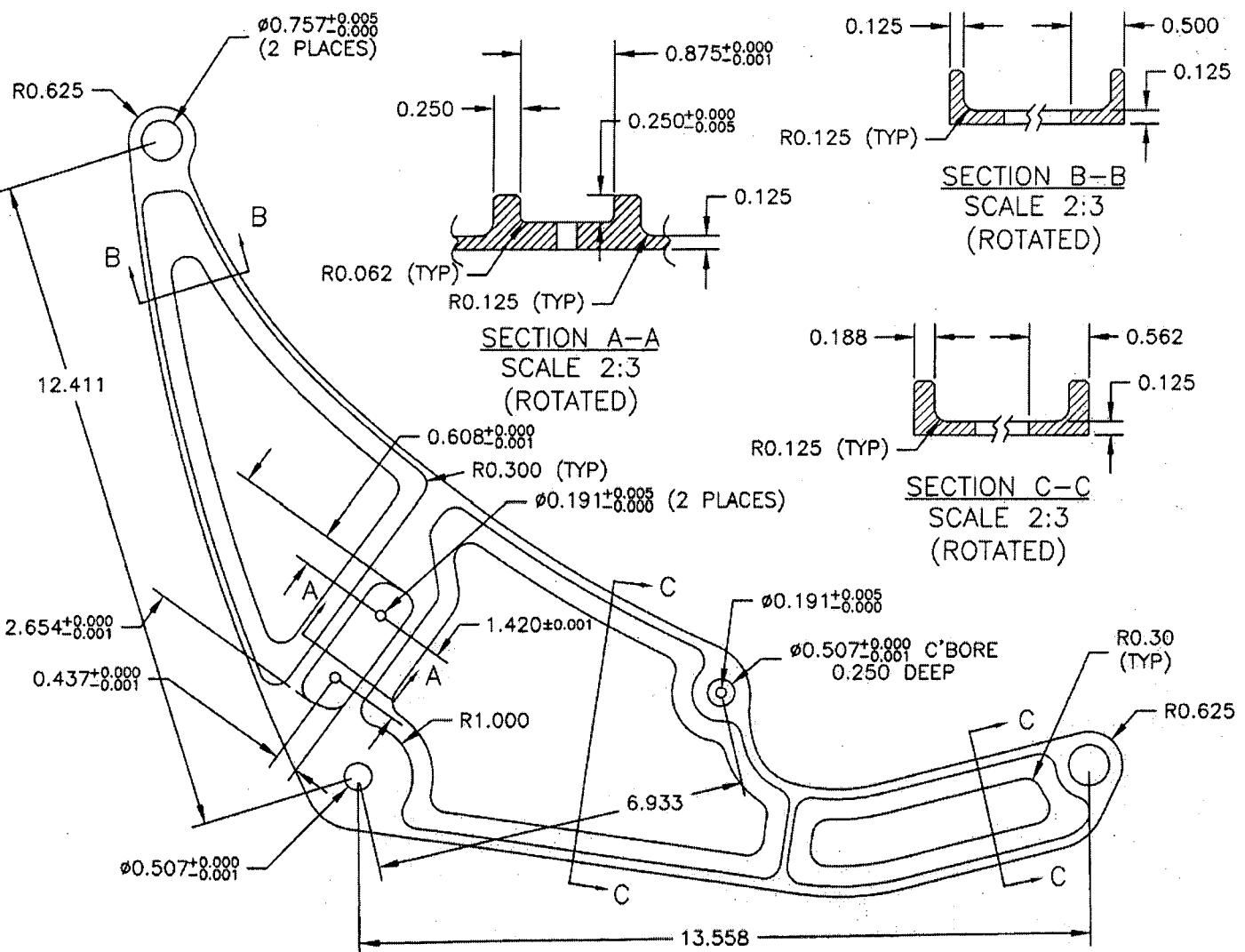
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B	SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84. BRACKET	SCALE 1:3	
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05.03.11 ~~✓~~



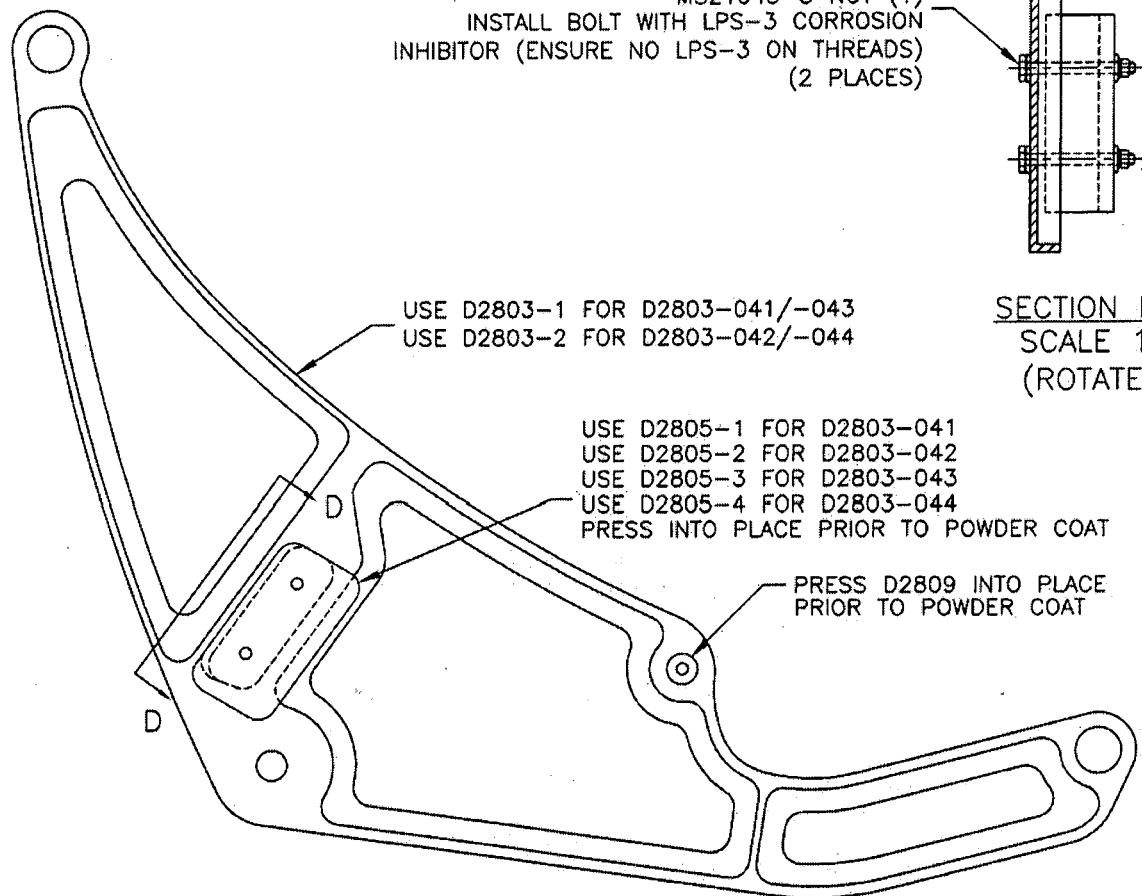
D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CK WITHOUT NOTICE  
WORK ORDER  
NO. 25918

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3

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